

# Work Order ID 128254

Tuesday, January 13, 2015 1:38:04 PM

**\*128254\***

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Item ID: D4542-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Retainer, Inner  
 Start Date: 1/13/2015 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 1/20/2015 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-----------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                     |                      |         |        |              |               |               |                  |                |
| D4542                          | F                                       |                      |         |        |              |               |               |                  |                |
| 100                            |                                         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |                                         |                      |         |        |              |               |               |                  |                |
| Waterjet                       | <b>Memo</b>                             | 0.00                 |         |        |              |               |               |                  |                |
| FLOW CNC Waterjet              | 1- Cut as per dwg                       |                      |         |        |              |               |               |                  |                |
| 6061-032                       | Prog rev: <u>F</u>                      |                      |         |        |              |               |               |                  |                |
|                                | Dwg rev: <u>F</u>                       |                      |         |        |              |               |               |                  |                |
|                                | 2- Deburr                               |                      |         |        |              |               |               |                  |                |
| 110                            | QC2- Inspect parts off machine FAI/FAIB | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |                                         |                      |         |        |              |               |               |                  |                |
| QC                             | <b>Memo</b>                             | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                         |                      |         |        |              |               |               |                  |                |

(10)

01/15/03

8

(10)

01/15/03

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**Accept**

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 1/13/2015      **Start Qty:** 8.00      **\*g\***

**Cust Item ID:**

**Required Date:** 1/20/2015      **Req'd Qty:** 8.00      **\*g\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

|     |       |       |
|-----|-------|-------|
| Run | Start | *NR1* |
|     | Stop  | *NR2* |

[illegible]

FEB 12 2015

**Work Order ID 128254**

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**\*128254\***

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Item ID: D4542-5      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Retainer, Inner  
Start Date: 1/13/2015      Start Qty: 8.00      **\*8\***      Cust Item ID:  
Required Date: 1/20/2015      Req'd Qty: 8.00      **\*8\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Identify as per dwg & Stock Location: <u>S1 (3)</u> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |                                                     |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                                | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                     |                      |         |        |              |               |               |                  |                |
| 140                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |                                                     |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                     |                      |         |        |              |               |               |                  |                |

D46  
27  
9-00

FEB 13 2015

15/2/17

15.2fb

# Picklist Print

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Page 1

Work Order ID: 128254

\*128254\*

Parent Item: D4542-5

\*D4542-5\*

Parent Item Name: Retainer, Inner

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B  
12.02.24 as per dwg reva DD verf:EC IPP REV:C 12.05.08 as  
per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg revD  
DD verf:JLM IPP REV:E 15.01.06 AS PER DWG REV.F DD  
VERF:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6S.032

Purchased

No

100

sf

139.1558

0.208

2

\*M6061T6S 032\*

\*\*

DL15/02/03

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

139.1558

m130387

64

m130585

75.1558

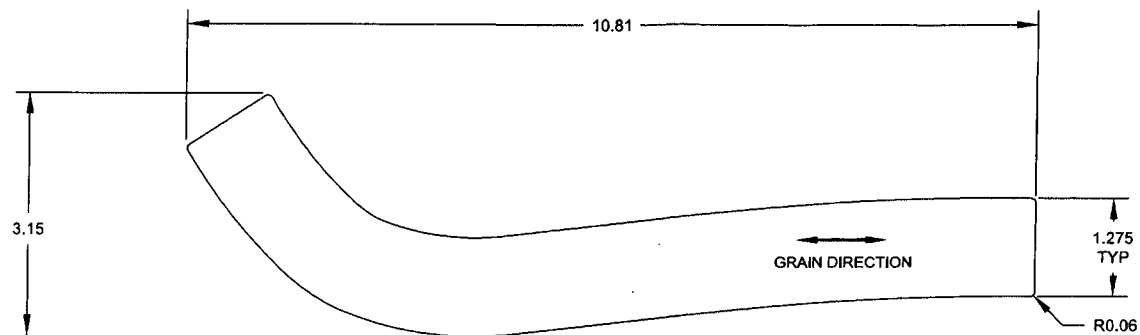
2.3333

|                                     |                     |                     |             |
|-------------------------------------|---------------------|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>           |                     | <b>Work Order:</b>  | 128254      |
| <b>Description:</b> Retainer, Inner |                     | <b>Part Number:</b> | D4542-5     |
| <b>Inspection Dwg:</b> D4542        | <b>Rev:</b> E F R M |                     | Page 1 of 1 |

[illegible]

|              |          |             |            |                       |  |
|--------------|----------|-------------|------------|-----------------------|--|
| Measured by: | DL       | Audited by: | 38<br>9-88 | Preliminary Approval: |  |
| Date:        | 15/02/03 | Date:       |            | Date:                 |  |

| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A   | 12.05.15 | New Issue                        | KJ         |          |
| B   | 12.09.26 | Dwg Rev updated                  | KJ         |          |
| C   | 13.05.08 | Dwg Rev updated                  | KJ         |          |
| D   | 14.10.08 | Dwg Rev updated                  | KJ         |          |
| E   | 14.11.04 | Dimensions revised per Dwg Rev E | KJ         |          |



**D4542-5 RETAINER, INNER**  
(TOP CORNER)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVF.DXF"

|            |          |                                                                                                                                                                                                                                                                                                  |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | CP       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                      |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. F       |
| MFG. APPR. |          | D4542                                                                                                                                                                                                                                                                                            | SHEET 4 OF 5 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   |          | RETAINER, INNER                                                                                                                                                                                                                                                                                  | NTS          |
| DATE       | 14.04.10 | <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

**RELEASED**  
2015-01-05  
JMT

128254.MJ  
1501-14